

Date: Tuesday, 28/04/2009 12:38:24 PM  
 User: Julie Dawson

## Process Sheet

|  |  |
|--|--|
| <b>Customer</b> : CU-DAR001 Dart Helicopters Services  | <b>Drawing Name</b> : SADDLE FITTING, AFT (OUTBOARD/INBOARD) |
| <b>Job Number</b> : 47567                              |  |
| <b>Estimate Number</b> : 10534                         |  |
| <b>P.O. Number</b> :                                   | <b>Part Number</b> : D2574                                   |
| <b>This Issue</b> : 28/04/2009 <b>S.O. No.</b> :       | <b>Drawing Number</b> : D2574 REV E                          |
| <b>Prsht Rev.</b> : NC                                 | <b>Project Number</b> : N/A                                  |
| <b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS  | <b>Drawing Revision</b> : E                                  |
| <b>Previous Run</b> : 47250                            | <b>Material</b> :  |
| <b>Written By</b> :                                    | <b>Due Date</b> : 07/05/2009 <b>Qty:</b> 8 <b>Um:</b> Each   |
| <b>Checked &amp; Approved By</b> : <u>JLD 09 04 28</u> |  |
| <b>Comment</b> : Est Rev: I As Per RevE 06-01-27 JLM   |  |

## Additional Product

Job Number:



|                |                              |                      |
|----------------|------------------------------|----------------------|
| <b>Seq. #:</b> | <b>Machine Or Operation:</b> | <b>Description :</b> |
|----------------|------------------------------|----------------------|

|     |          |               |
|-----|----------|---------------|
| 1.0 | D6101005 | Saddle Billet |
|-----|----------|---------------|



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)  
 7075-T7351 8.25X5.0X2.5  
 Make from D6101-005 billet for D2574  
 Ensure that grain is along 5.00" length  
 Batch No: 34874X5 46411X3

|     |       |                                |
|-----|-------|--------------------------------|
| 2.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



**Comment:** HAAS CNC VERTICAL MACHINING #1

Program Batch No. JL Double check by: JS

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets  
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets  
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets  
 4-Deburr and remove all machining marks  
 5-Tumble to remove sharp edges.

JL 09/05/08

|     |               |                              |
|-----|---------------|------------------------------|
| 3.0 | MILLING CONV. | CONVENTIONAL MILLING MACHINE |
|-----|---------------|------------------------------|



**Comment:** CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2573 & D2574

JL 09/05/08

|     |     |  |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

JL 09/05/08

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Tuesday, 28/04/2009 12:38:25 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 47567

Part Number: D2574

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

88 09/05/08

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MD / FL

09/05/11

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 11/472

START TIME:

10:15

OVEN TEMPERATURE:

320°

FINISH TIME:

10:45

FL 09/05/11

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

BR 09-05-11

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 434

A 09-05-11 (8)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/12

Job Completion



MF 09-05-11

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

|   |  |                           |
|---|--|---------------------------|
| <b>DART AEROSPACE LTD</b>               |  | <b>Work Order:</b> 47567  |
| <b>Description:</b> Saddle, Aft Inboard |  | <b>Part Number:</b> D2574 |
| <b>Inspection Dwg:</b> D2574 Rev. E     |  | <b>Page 1 of 1</b>        |

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

|               |       |       |                | Recorded Actual Dimensions |       |       |       |    |      |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| Dim           | Min   | Max   | Go/No Go Gauge | 1                          | 2     | 3     | 4     | By | Date |
| A             | 0.438 | 0.443 |                | .439                       | .439  | .439  | .439  |    |      |
| B             | 1.745 | 1.755 |                | 1.750                      | 1.750 | 1.750 | 1.750 |    |      |
| C             | 3.495 | 3.505 |                | 3.500                      | 3.500 | 3.500 | 3.500 |    |      |
| D             | 1.745 | 1.755 |                | 1.750                      | 1.750 | 1.750 | 1.750 |    |      |
| E             | 7.990 | 8.010 |                | 7.999                      | 7.999 | 7.999 | 7.999 |    |      |
| F             | 0.490 | 0.510 |                | .500                       | .501  | .499  | .500  |    |      |
| G             | 0.257 | 0.262 |                | .259                       | .259  | .259  | .259  |    |      |
| H             | 0.375 | 0.380 |                | .376                       | .376  | .376  | .376  |    |      |
| I             | 0.490 | 0.510 |                | .499                       | .498  | .499  | .498  |    |      |
| J             | 1.174 | 1.184 |                | 1.179                      | 1.179 | 1.179 | 1.179 |    |      |
| K             | 0.558 | 0.578 |                | .568                       | .567  | .568  | .567  |    |      |
| L             | 1.174 | 1.184 |                | 1.179                      | 1.179 | 1.179 | 1.179 |    |      |
| M             | 1.365 | 1.375 |                | 1.370                      | 1.370 | 1.370 | 1.370 |    |      |
| N             | 2.495 | 2.505 |                | 2.500                      | 2.500 | 2.500 | 2.500 |    |      |
| O             | 4.119 | 4.129 |                | 4.124                      | 4.124 | 4.124 | 4.124 |    |      |
| P             | 0.115 | 0.135 |                | .125                       | .126  | .126  | .126  |    |      |
| Q             | 0.115 | 0.135 |                | .135                       | .135  | .135  | .135  |    |      |
| R             | 0.240 | 0.260 |                | .250                       | .250  | .250  | .250  |    |      |
| S             | 0.115 | 0.135 |                | .126                       | .124  | .122  | .123  |    |      |
| T             | 0.178 | 0.198 |                | .188                       | .188  | .188  | .188  |    |      |
| U             | 3.210 | 3.250 |                | 3.229                      | 3.230 | 3.230 | 3.230 |    |      |
| V             | 0.230 | 0.250 |                | .242                       | .239  | .240  | .240  |    |      |
| W             | 0.115 | 0.135 |                | .130                       | .126  | .125  | .127  |    |      |
| X             | 0.307 | 0.312 |                | .307                       | .312  | .311  | .310  |    |      |
| Y             | 0.760 | 0.765 |                | .760                       | .760  | .760  | .760  |    |      |
| Z             | 0.352 | 0.372 |                | .363                       | .364  | .362  | .361  |    |      |
| AA            | 0.470 | 0.530 |                | .500                       | .500  | .500  | .500  |    |      |
| AB            | 0.615 | 0.635 |                | .625                       | .626  | .626  | .626  |    |      |
| AC            | 0.053 | 0.073 |                | .063                       | .063  | .063  | .063  |    |      |
| AD            | 0.240 | 0.260 |                | .248                       | .246  | .246  | .246  |    |      |
| AE            | 1.500 | 1.520 |                | 1.511                      | 1.514 | 1.514 | 1.514 |    |      |
| AF            | 0.115 | 0.135 |                | .135                       | .135  | .135  | .135  |    |      |
| AG            | 0.240 | 0.280 |                | .270                       | .270  | .270  | .270  |    |      |
| AH            | 0.240 | 0.260 |                | .250                       | .247  | .250  | .249  |    |      |
| AI            | 2.000 | 2.020 |                | 2.001                      | 2.004 | 2.004 | 2.004 |    |      |
| AJ            | 0.023 | 0.043 |                | .033                       | .033  | .033  | .033  |    |      |
| Accept/Reject |       |       |                |                            |       |       |       |    |      |

|                 |
|-----------------|
| Measured by: JL |
| Date: 09/05/07  |

|                |
|----------------|
| Audited by: JB |
| Date: 09/05/07 |

| Rev | Date     | Change                                  | Revised by | Approved |
|-----|----------|---|------------|----------|
| A   |          | New Issue                               | RF         |          |
| B   | 02.09.27 | Re-format; Added Rev. D                 | KJ         |          |
| C   | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ         |          |
| D   | 05.05.05 | Added dimension AI                      | KJ/RF      |          |
| E   | 05.12.05 | Added dimension AJ                      | KJ/JLM     |          |

|   |  |                           |
|---|--|---------------------------|
| <b>DART AEROSPACE LTD</b>               |  | <b>Work Order:</b> 475167 |
| <b>Description:</b> Saddle, Aft Inboard |  | <b>Part Number:</b> D2574 |
| <b>Inspection Dwg:</b> D2574 Rev. E     |  | <b>Page 1 of 1</b>        |

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

|               |       |       |                | Recorded Actual Dimensions |       |       |       |    |      |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| Dim           | Min   | Max   | Go/No Go Gauge | 45                         | 46    | 47    | 48    | By | Date |
| A             | 0.438 | 0.443 |                | .440                       | .440  | .440  | .440  |    |      |
| B             | 1.745 | 1.755 |                | 1.750                      | 1.750 | 1.750 | 1.750 |    |      |
| C             | 3.495 | 3.505 |                | 3.500                      | 3.500 | 3.500 | 3.500 |    |      |
| D             | 1.745 | 1.755 |                | 1.750                      | 1.750 | 1.750 | 1.750 |    |      |
| E             | 7.990 | 8.010 |                | 7.999                      | 7.999 | 7.999 | 7.999 |    |      |
| F             | 0.490 | 0.510 |                | .495                       | .500  | .497  | .497  |    |      |
| G             | 0.257 | 0.262 |                | .259                       | .259  | .259  | .259  |    |      |
| H             | 0.375 | 0.380 |                | .376                       | .376  | .376  | .376  |    |      |
| I             | 0.490 | 0.510 |                | .498                       | .498  | .498  | .500  |    |      |
| J             | 1.174 | 1.184 |                | 1.179                      | 1.179 | 1.179 | 1.179 |    |      |
| K             | 0.558 | 0.578 |                | .566                       | .567  | .566  | .569  |    |      |
| L             | 1.174 | 1.184 |                | 1.179                      | 1.179 | 1.179 | 1.179 |    |      |
| M             | 1.365 | 1.375 |                | 1.370                      | 1.370 | 1.370 | 1.370 |    |      |
| N             | 2.495 | 2.505 |                | 2.500                      | 2.500 | 2.500 | 2.500 |    |      |
| O             | 4.119 | 4.129 |                | 4.124                      | 4.124 | 4.124 | 4.124 |    |      |
| P             | 0.115 | 0.135 |                | .126                       | .126  | .126  | .126  |    |      |
| Q             | 0.115 | 0.135 |                | .135                       | .135  | .135  | .135  |    |      |
| R             | 0.240 | 0.260 |                | .250                       | .251  | .250  | .251  |    |      |
| S             | 0.115 | 0.135 |                | .125                       | .125  | .125  | .124  |    |      |
| T             | 0.178 | 0.198 |                | .188                       | .188  | .188  | .188  |    |      |
| U             | 3.210 | 3.250 |                | 3.230                      | 3.230 | 3.230 | 3.230 |    |      |
| V             | 0.230 | 0.250 |                | .241                       | .239  | .240  | .240  |    |      |
| W             | 0.115 | 0.135 |                | .127                       | .126  | .125  | .126  |    |      |
| X             | 0.307 | 0.312 |                | .310                       | .310  | .310  | .310  |    |      |
| Y             | 0.760 | 0.765 |                | .760                       | .760  | .760  | .760  |    |      |
| Z             | 0.352 | 0.372 |                | .363                       | .362  | .361  | .362  |    |      |
| AA            | 0.470 | 0.530 |                | .500                       | .500  | .500  | .500  |    |      |
| AB            | 0.615 | 0.635 |                | .626                       | .625  | .626  | .625  |    |      |
| AC            | 0.053 | 0.073 |                | .063                       | .063  | .063  | .063  |    |      |
| AD            | 0.240 | 0.260 |                | .248                       | .246  | .246  | .246  |    |      |
| AE            | 1.500 | 1.520 |                | 1.514                      | 1.514 | 1.514 | 1.514 |    |      |
| AF            | 0.115 | 0.135 |                | .135                       | .135  | .135  | .135  |    |      |
| AG            | 0.240 | 0.280 |                | .270                       | .270  | .270  | .270  |    |      |
| AH            | 0.240 | 0.260 |                | .249                       | .247  | .248  | .248  |    |      |
| AI            | 2.000 | 2.020 |                | 2.004                      | 2.004 | 2.004 | 2.004 |    |      |
| AJ            | 0.023 | 0.043 |                | .033                       | .033  | .033  | .033  |    |      |
| Accept/Reject |       |       |                |                            |       |       |       |    |      |

|                        |
|------------------------|
| Measured by: <u>JK</u> |
| Date: <u>09/05/08</u>  |

|                       |
|-----------------------|
| Audited by: <u>SB</u> |
| Date: <u>09/05/08</u> |

| Rev | Date     | Change                                  | Revised by | Approved |
|-----|----------|---|------------|----------|
| A   |          | New Issue                               | RF         |          |
| B   | 02.09.27 | Re-format; Added Rev. D                 | KJ         |          |
| C   | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ         |          |
| D   | 05.05.05 | Added dimension AI                      | KJ/RF      |          |
| E   | 05.12.05 | Added dimension AJ                      | KJ/JLM     |          |

RELEASED

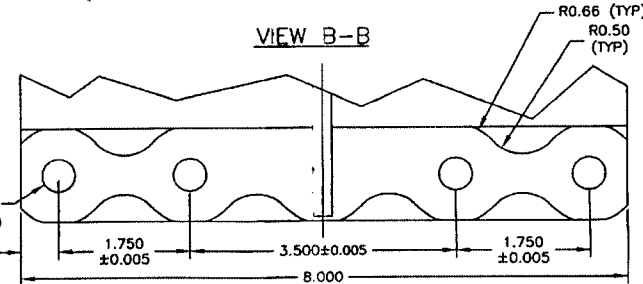
05.12.06

# NOTES

MATERIAL: 7075-T7351 (00-A-250/12)  
(REF DART SPEC. D6102-003)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C) E

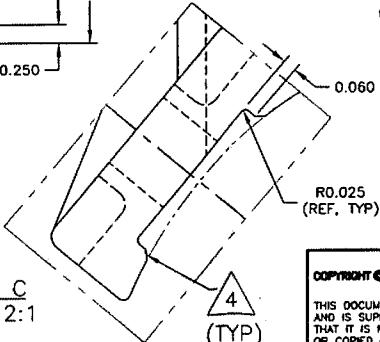
## VIEW B-B



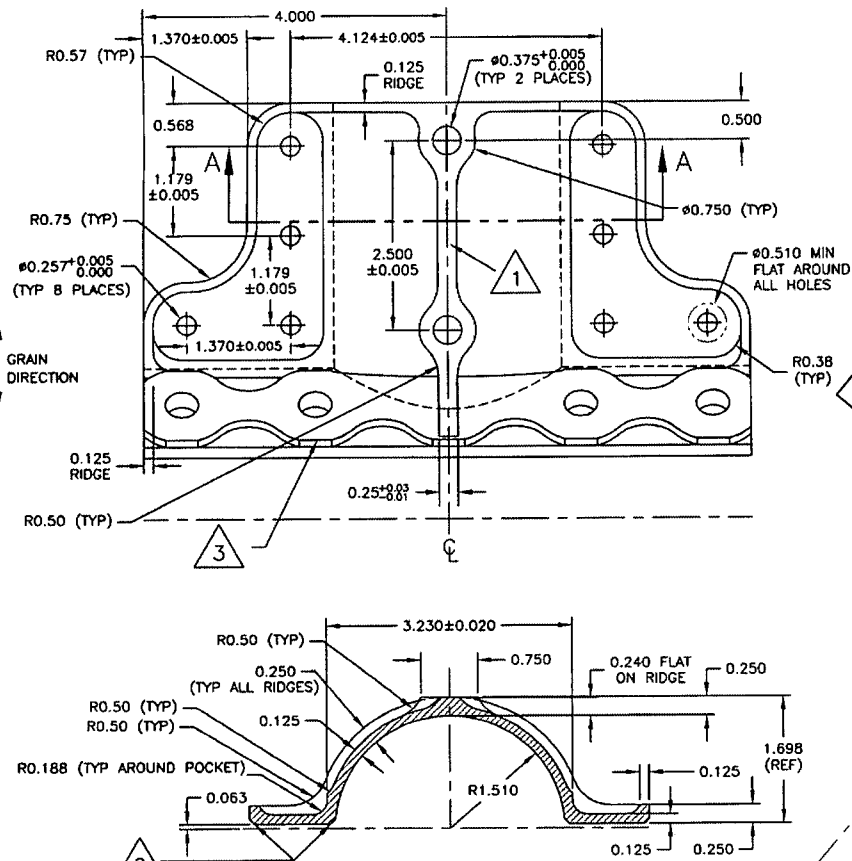
|         |          |  |
|---------|----------|--|
| E       | 05.07.13 | ADD CHAMFER ON RIDGE NOTE 4                                |
| D       | 02.09.06 | ADD RIDGES; TIGHTEN TOLERANCES                             |
| C       | 99.10.22 | INCORP. DEO 9123/9079/9102<br>ADD DIMENSIONS PER TSR A1177 |
| B       | 96.12.02 | ADD GRAIN DIR., 0.438 WAS 0.425                            |
| A       | 96.09.16 | NEW ISSUE  |
| DESIGN  | DS       | DRAWN BY PH  |
| CHECKED |          | APPROVED   |
| DATE    | 05.07.13 | DRAWING NO. 02574  |
|         |          | FILE   |
|         |          | INNER AFT SADDLE   |
|         |          | REV. E   |
|         |          | SHEET 1 OF 1   |
|         |          | SCALE 2:3  |

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## DETAIL C SCALE 2:1



## SECTION A-A



SHOP COPY  
RETURN TO  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 1150